

Work Order ID 135081

Wednesday, July 29, 2015 11:01:25 AM

647.3802
B 135081
REV. N/C

135081

Page 1

Item ID: 647.3802

Revision ID:

Item Name: 212 Upper Cutter Assy

Start Date: 7/28/2015 Start Qty: 1.00

Required Date: 7/29/2015 Req'd Qty: 1.00

Reference: RMA RA112081

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer: CAGRA01

Approvals: Process Plan: umf Date: 15-7-29 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.3800	n/c

100 0.00

100

QC

Quality Control

Memo

INSPECT RA 112081 647.3802 X 1 B123240

PARTS ARE COMPLETE

ID AND STOCK UNDER NEW BATCH NUMBER

110 Identify as per dwg & Stock Location: _____ 0.00

110

Packaging

Packaging

Memo

0.00

① 15-08-06

DAS
9
9-89

P.T.O.

DAS
27
9-89

AUG 12 2015

DQA: Aut Date: 15/08/24

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 15/08/18 Date: 15/08/18Work Order update only ☐

Work Order: <u>135081</u> Part No. <u>647.3802</u> NCR No. <u>15-5250</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☒</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☒	Supplier ☐																																																
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Date: <u>15-08-06</u>	Step #: <u>100</u>	QTY Effective: <u>2</u>	MRB (QS1042) Approval DAS 9 9-89 <u>15-08-06</u>																																																																	
Description Work Order Deviation		Disposition		Completed By DAS																																																																
wrong part was pull during assy. R.C. lack of attention <u>647.3802</u>		scrap + destroy 647.3801 (no traceability) replace with 647.3811 B127750 and assy. has per dwg. 647.3800 During assy. it was found that 646.9701 was also <u>MS 27039-0819 M131317 (3x)</u> <u>MS 21042208 M131697 (3x)</u> <u>NAS1149FA/832P M125268 (6x)</u>		15/08/10 36 9-89																																																																
				Lead hand / Supervisor Approval Verification <u>38</u> 9-89 <u>11/11/2015</u>																																																																
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Work Order ID 135081

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135081

Page 2

Item ID: 647.3802 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 212 Upper Cutter Assy
Start Date: 7/28/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/29/2015 Req'd Qty: 1.00 ***1*** Customer: CAGRA01
Reference: RMA RA112081

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC21- Final Inspection - Work Order Release	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ AUG 12 2015

MLJ AUG 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

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Page 1

Work Order ID: 135081

135081

Parent Item: 647.3802

647 3802

Parent Item Name: 212 Upper Cutter Assy

Start Date: 7/28/2015

Required Date: 7/29/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.3802		Manufactured	No				Each	19.0000		1			

647 3802

212 Upper Cutter Assy

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
cck030	19	
124717	12	
124719	2	
124722	2	
124723	2	
124724	1	

1X 123240
MF
15-7-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

RA112081

Received @ June 26, 2015
Inspected@ July 20, 2015

CUSTOMER: AGRARFLUG HELILIFT GMBH
CUSTOMER CONTACT: HANS KRASKES
SHIPPED FROM: AHLEN GERMANY

Instructions for RA112081 647.3802 B123240

- Part inspected and complete
- Identify with new batch number and stock

Time Estimate: 1 hour

Departments Required: quality, store

Pictures Attached: N/A

QTY INSPECTED: 1x 647.3802 B123240

**THIS INSTRUCTION SHEET
MUST BE ATTACHED TO THE
RESTOCKING WORK ORDER
AT ALL TIMES!!!!**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					